

Taiwanese Patent Publication No. 469144**Method for joining striking faceplate and shell of golf club head**

The present invention relates to a method for joining a striking
5 faceplate and a shell of a golf club head (addendum II). The shell of
the club head is made of metal. The method comprises: forming a
groove at a location on the striking face, in which the groove is
formed with a hole and the bottom of the groove is formed with a
shoulder; installing a solder material on the shoulder, in which the
10 melting point of the solder material is lower than the melting point of
the shell of the club head and the striking faceplate, and the striking
faceplate is also made of metal; mounting the faceplate in the groove
of the shell of the club head so that the bottom of the plate and the
shoulder of the groove press on the solder material; mounting the
15 composite in a vacuum furnace or a high temperature furnace in an
inert gas for heating at a temperature lower than the melting points
of the shell of the club head and the striking faceplate and higher
than the melting point of the solder material in order to melt the
solder material and allow the solder material to fill up the junction
20 face between the shell of the club head and the striking faceplate so
that the striking faceplate is securely soldered on the shell of the
club head. The method is characterized in that: a soldering is carried
out along the joining seam between the striking faceplate and the
shell of the club head on the outer surface of the club head, followed
25 by surface grinding and polishing.

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發明

全 2 頁

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[54]名稱：高爾夫桿頭殼體與擊球面板片之接合方法追加二

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[57]申請專利範圍：

一種高爾夫桿頭殼體與擊球面板片之接合方法追加二，該桿頭殼體是以金屬製成，其擊球面位置設有一凹槽，凹槽中間設一凹洞，而在凹槽底面形成一肩面，該擊球面板片亦是以金屬製成，係嵌設在該桿頭殼體之凹槽中，用以形成桿頭之擊球面，在該擊球面板片置入桿頭殼體凹槽之前，先在殼體凹槽肩面上放置焊接材料，該焊接材料是以與桿頭殼體及擊球面板片不同材質之金屬粉末製成，其融點溫度必須低於桿頭殼體及擊球面板片金屬之融點，然後將擊球面板片嵌入殼體凹槽，使板片底面與凹槽肩面夾壓該焊接材料，再將其置入真空爐或有惰性氣體保護下之高溫爐中加熱，其加熱溫度要低於桿頭殼體及擊球

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面板片之融點，而高於焊接材料之融點，使焊接材料熔融，並利用毛細作用充填滿桿頭殼體與擊球面板片之鄰接面，使擊球面板片牢固的焊接在桿頭殼體上，其特徵在於：然後再自桿頭之外表面，沿著該擊球面板片與桿頭殼體之接合縫予以焊接，最後再表面研磨及拋光處理。

圖式簡單說明：

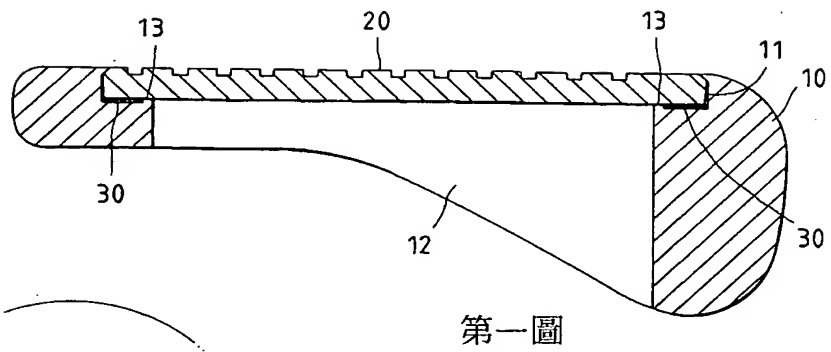
10. 第一圖是母案的結構示意圖。

第二圖是超薄面板在擊球瞬間產生彈性變形而導致破裂隙縫的示意圖。

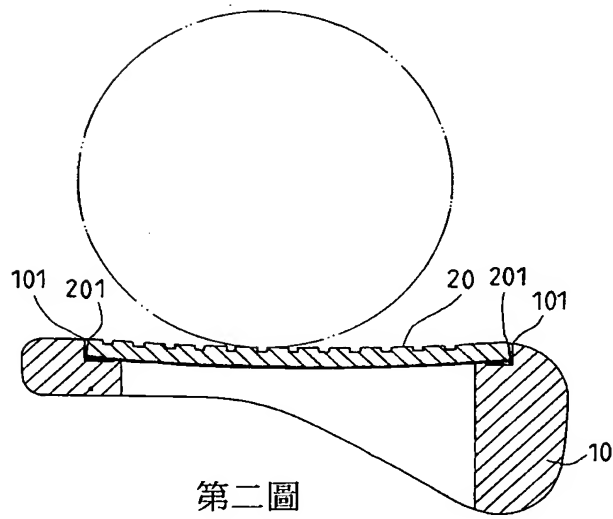
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15. 第四圖是本追加發明的成品結構示意圖。

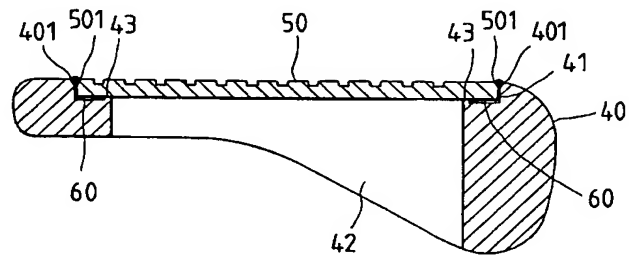
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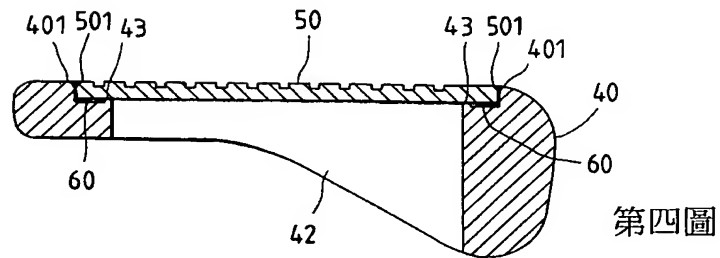
第一圖



第二圖



第三圖



第四圖